

Work Order ID 78918-2

\*78918\*

Page 1

January-17-12 9:00:53 AM

Item ID: D3197-041

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Bar Assembly

Start Date: 17/01/2012 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 31/01/2012 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals: Process Plan: M C J

Date: 12/01/17

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3197

Rev B

100

0.00

\*100\*

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 29.125" long

12/01/24  
B.A 12/02/02

6

6

110

0.00

\*110\*

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Face ends to length per dwg D31972-Machine D3197-1 as per Folio FA340  
and Dwg D31973-Debur

12/01/24

12/02/03

6

120

0.00

\*120\*

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

12/01/24

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 78918

**\*78918\***

Page 2

January-17-12 9:00:53 AM

Item ID: D3197-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Bar Assembly  
 Start Date: 17/01/2012 Start Qty: 6.00 **\*6\*** Cust Item ID:  
 Required Date: 31/01/2012 Req'd Qty: 6.00 **\*6\*** Customer:  
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	CONVENTIONAL LATHE	0.00							
<b>*130*</b>									
Lathe Conv	Memo	0.00	B.A	12/02/02		6	φ		
Conventional Lathe	Chamfer as per Dwg D3197								
140	QC8- Inspect parts - second check	0.00							
<b>*140*</b>									
QC	Memo	0.00		and 12/02/05		6	φ		
Quality Control									
150	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*150*</b>									
HandFinish	Memo	0.00							
Hand Finishing									

C BL 12-2-6.

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*78918\***

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 Start Date: 17/01/2012 Start Qty: 6.00 **\*6\*** Cust Item ID:  
 Required Date: 31/01/2012 Req'd Qty: 6.00 **\*6\*** Customer:  
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190 QC5- Inspect part completeness to step on W/O 0.00

**\*190\***

QC

Quality Control

Memo

0.00

200

Identify as per dwg & Stock Location: 260 0.00

**\*200\***

Packaging

Packaging

Memo

0.00

210

QC21- Final Inspection - Work Order Release 0.00

**\*210\***

QC

Quality Control

Memo

0.00

8/17/02/10

(24)

CE 12/4/10 (4)

12/12/13

MLJ 12/02/13

12-02-13  
(H)

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries



# Picklist Print

January-17-12 9:00:57 AM

Page 1

Work Order ID: 78918

\*78918\*

Parent Item: D3197-041

\*D3197-041\*

Parent Item Name: Bar Assembly

Start Date: 17/01/2012

Required Date: 31/01/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev: A New Issue 05-11-08 JLM  
IPP Rev: B As per Rev B 06-03-10 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS27039-1-24

Purchased

No

100

Each

70.0000

2

12

\*MS27039-1-24\*

Screw

\*\*

Location

Loc Qty

Loc Code

ST292

70

100151

70

AN960JD10

NAS1149D0363J

Purchased

No

180

Each

0.0000

6

36

\*AN960JD10\*

Washer

4 M119537

\*\*

D2690-5

Manufactured

No

180

Each

5.0000

2

12

\*D2690-5\*

Lanyard Assembly

\*\*

Location

Loc Qty

Loc Code

ST013

5

73321

5

D3242-1

Manufactured

No

180

Each

8.0000

2

12

\*D3242-1\*

Tag

\*\*

Location

Loc Qty

Loc Code

ST034

8

76162

8

B79514 (7x)

B79825 (4x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Page 2

Work Order ID: 78918

\*78918\*

Parent Item: D3197-041

\*D3197-041\*

Parent Item Name: Bar Assembly

Start Date: 17/01/2012

Required Date: 31/01/2012

Start Qty: 6.00

Required Qty: 6.00

D3489-3-200

Manufactured No

180 Each

8.0000

2

12

\*D3489-3-200\*

PIP PIN

\*\*

Location

Loc Qty

Loc Code

GA

8

75792

8

M7075T73R1.000

Purchased No

180

f

25.5150

2.42

18.15

\*M7075T73R1 000\*

7075-T73 Rd Bar 1.00

\*\*

Location

Loc Qty

Loc Code

MAT012

25.515

115165

2.7

116405

4.54

116604

2.25

116835

2.32

116962

0.905

118305

12

119049

0.8

M 102503

14.6250 ft

MS21042L3

Purchased No

180

Each

5.787.000

2

12

\*MS21042L 3\*

Nut

\*\*

Location

Loc Qty

Loc Code

ST300

5787

117441

16

117885

32

118451

5

118927

3

119017

5259

119075

472

January-17-12 9:00:57 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

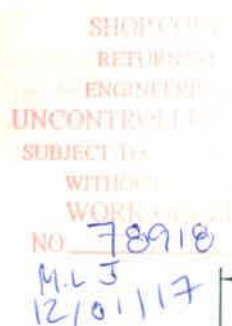
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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[illegible]**DART**

ENGRAVE DART LOGO USING  
0.250 HIGH x 0.005 DEEP LETTERING  
AND P/N USING 0.150 HIGH x 0.005  
DEEP LETTERING ON BOTH SIDES

- 1) MATERIAL: 7075-T73 ROUND BAR (QQ-A-200/11 or QQ-A-225/9)  $\phi$ 1.000 O.D.  
(REF DART SPEC. M7075T73R1.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) FOR TOOLING, IT IS ACCEPTABLE TO HAVE A 0.06 DEEP x 60° CENTER MARK AT EITHER  
END OF THE BAR

DESIGN		DRAWN BY		<b>DART AEROSPACE LTD</b> HAMKESBURY, ONTARIO, CANADA	
CHECKED	CP	APPROVED	CP		
DATE	06.01.10			DRAWING NO.	REV. B
				D3197	SHEET 1 OF 1
				TITLE	SCALE
				BAR	1:1
A	03.07.01			NEW ISSUE	
B	06.01.10			CHG PIP PIN; ADD D3242-1 TAG	

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